

Date: Thursday, 3/30/2006 8:34:47 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 26439		
Estimate Number	: 10466		
P.O. Number	: N/A	Part Number	: D33891
This Issue	: 3/30/2006 S.O. No. : N/A	Drawing Number	: D3389 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 26438	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 4/20/2006
Checked & Approved By	: <u>06.03.30</u>	Qty:	1 Um: Each
Comment	: Est Rev:A 06.08.31 New issue KJ/JLM : Est Rev:B 06-02-08 As per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1" Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ext'n -1" Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
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1	D2500-3-100	Web Extrusion	
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B19674 Pm' 06-04-03 (1)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

Pm' 06-04-03 (1)

2-Drill pilot holes using DT8785 as per Dwg D3389

Pm' 06-04-03 (1)

3-Open 1X .257" Dia Hole

Pm' 06-04-03

4-Open Remaining holes to finish size as per Dwg D3389

Pm' 06-04-03 (1)

5-Deburr

Pm' 06-04-03 (1)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

06-04-03 (1)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 06-04-03

(1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/30/2006 8:34:47 AM  
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## Process Sheet

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Drawing Name: 412 WEB

Job Number: 26439

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*De 06/04/05 (1)*

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

*DP06-4-6*

*(1)*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DP06/04/10 (1)*

Job Completion



*VL 06.04.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

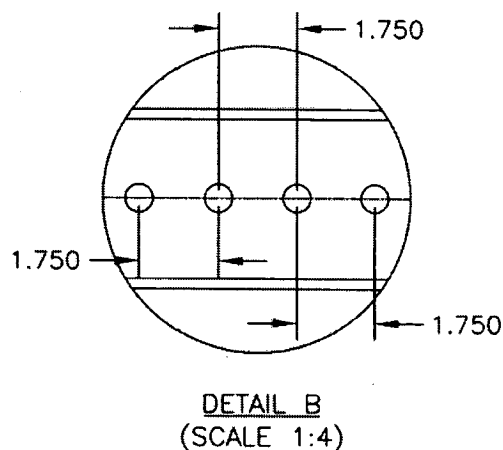
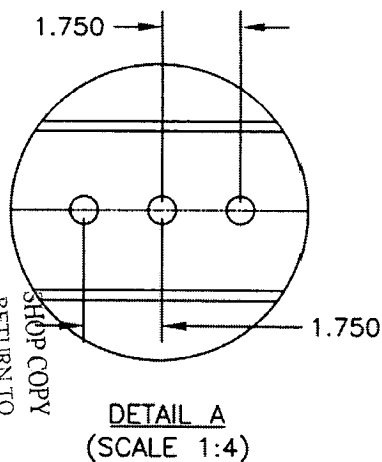
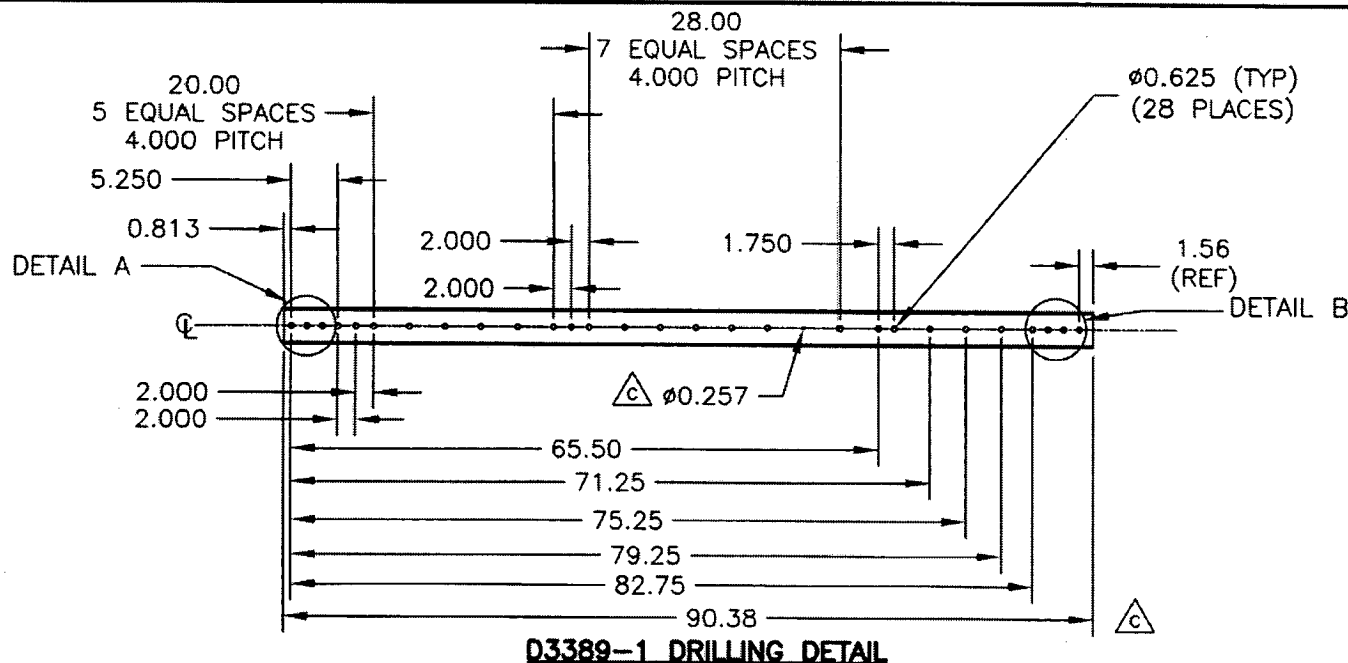
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

RELEASE  
06.01.23

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.01.23	DRAWING NO.	D3389	REV. C
		TITLE	412 WEB	SHEET 1 OF 1
				SCALE
A		05.02.07	NEW ISSUE	1:20
B		05.06.13	UPDATE DIMENSIONING	
C		06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE	



**D3389-1 412 WEB**

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26439  
RETURN TO  
ENGINEERING  
SHOP COPY